

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																
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Work Order ID 149753

July 28, 2016 11:31:40 AM

149753

Page 2

Item ID: D3049-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Bearpaw
Start Date: 7/29/2016 Start Qty: 12.00 ***12*** Cust Item ID:
Required Date: 8/12/2016 Req'd Qty: 12.00 ***12*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140 *140* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.04		D. 16/08/29		12	0		DAS 08 9-89
170 *170* Packaging Packaging	Identify as per dwg & Stock Location: <u>SK</u> Packaging Memo	0.00 0.02		PP, 49766		<u>8/29/16</u>			AUG 29 2016
180 *180* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.20				<u>Roll</u>			AUG 29 2016
									DAS 21 9-89 AUG 29 2016

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Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

Picklist Print

Page 1

July 28, 2016 11:32:01 AM

Work Order ID: 149753

149753

Parent Item: D3049-1

D3049-1

Parent Item Name: Bearpaw

Start Date: 7/29/2016

Required Date: 8/12/2016

Start Qty: 12.00

Required Qty: 12.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MUHMWB10		Purchased	No			120	sf	424.7600	3.4	40.8			

MUHMWB10

UHMW 1" Black - 48"x120" Tivar Mfg.#52480104

Da 16/07/31

Location

Loc Qty

Loc Code

MAT018

424.76

m134823

83.5

m135013

341.26

45.5

DART AEROSPACE LTD		Work Order:	149753
Description: Bearpaw		Part Number:	D3049-1
Inspection Dwg: D3049	Rev: A B <i>16/08/24</i>	Page 1 of 1	

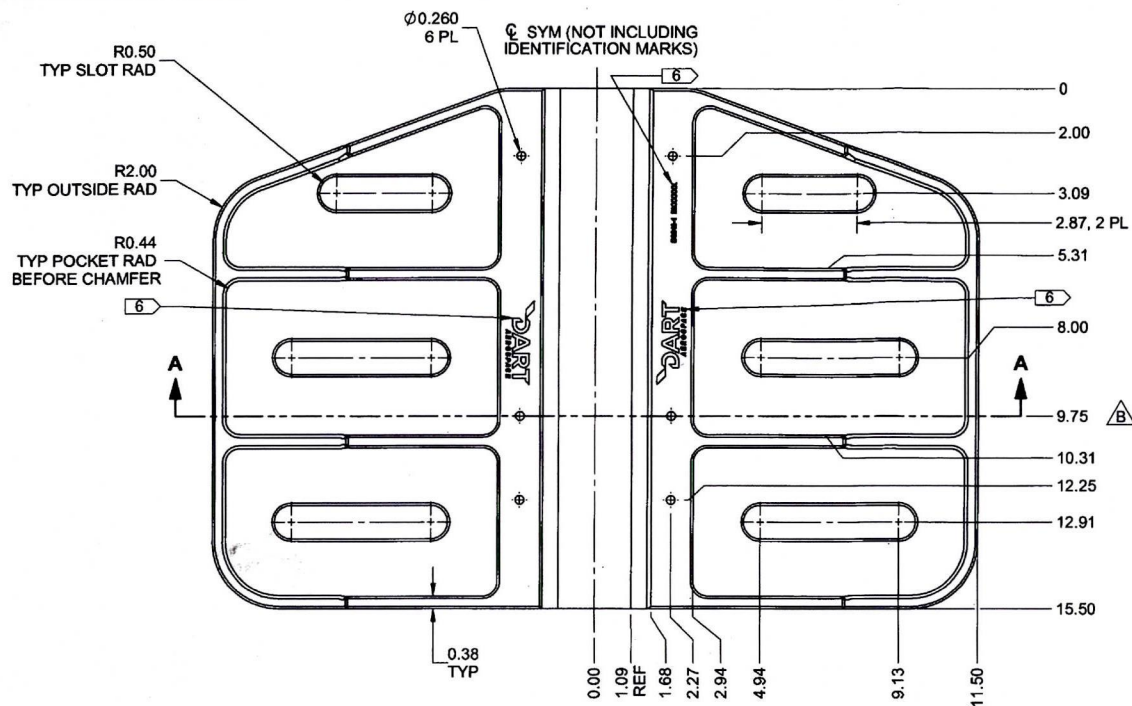
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

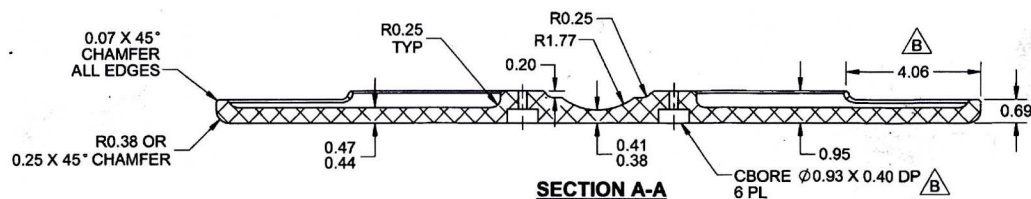
Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	Ø0.260	+0.005/-0.000	.260	/		Vern	FK-04
B	0.93	+/-0.030	.93	/		"	"
C	0.40	+0.030/-0.000	.415	/		"	"
D	2.00	+/-0.030	2.00	/		"	"
E	10.250	+/-0.010	10.250	/		Vern	CNE-02
F	4.540	+/-0.030	4.54	/		Vern	FK-04
G	5.88	+/-0.030	5.877	/		"	"
H	0.38	+/-0.030	.375	/		"	"
I	11.50	+/-0.030	11.50	/		Tape	FK-05
J	0.07 x 45°	+0.030/-0.010	.07 x 45°	/		Vern	FK-04
K	0.44 - 0.47	+/-0.000	.445	/		"	"
L	R0.25	+/-0.030	.25	/		R-G.	
M	0.38	+/-0.010	.38	/		Vern	FK-04
N	0.95	+0.030/-0.010	.954	/		"	"
O	0.69	+/-0.030	.686	/		"	"
P	0.20	+/-0.030	.199	/		"	"
Q	23.00	+/-0.030	23.00	/		Tape	FK-05
R	0.25 x 45°	+/-0.030	.25 x 45°	/		Vern	FK-04
	2.50	+/-0.030	2.500	/		"	"

Measured by:	DAS 44 9-89	Audited by:		Prototype Approval:	N/A
Date:	16-08-24	Date:		Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue P/O D135-692-011	KJ/RF	
B	08.05.06	Dimension I revised	KJ/DD	



D3049-1 BEARPAW



SECTION A-A

NOTES:

- 1) MATERIAL: UHMW BLACK TIVAR 1000 VIRGIN MATERIAL, 1.00 THICK MACHINED TO 0.95 (REF DART SPEC. MUHMBW10)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE DART LOGO, PART NUMBER "D3049-1" AND BATCH NUMBER "BXXXXX" IN ACCORDANCE WITH QSI 044 METHOD 6.3 TO MAX DEPTH OF 0.012 AS ILLUSTRATED
- 7) WEIGHT: 5.94 lbs
- 8) NON DIMENSIONED FEATURES PER CAD FILE "D3049-1-REVB.STP"

RELEASED
2016-07-26
ECN 16-591

APPROVED

B	REVISE DWG TO CURRENT STANDARDS, ADDED 2 ADDITIONAL CBORE HOLES ZN C6-1, UPDATE DIM'S DUE TO CAD ERROR. Ø0.93 WAS Ø0.75	ML	16.06.01
A	NEW ISSUE	RF	01.10.18
REV.	DESCRIPTION	BY	DATE
DESIGN	ML	DART AEROSPACE USA, INC. EUGENE, OR	
DRAWN	ML		
CHECKED	DB	DRAWING NO.	REV. B
MFG. APPR.	JLM	D3049	SHEET 1 OF 1
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	BEARPAW	NTS
DATE	16.06.01	COPYRIGHT © 2001 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

SLA
7/28/16
149753

ENGINEERING CHANGE NOTICE

DART AEROSPACE LTD

Date: 16.07.11	Job No.: ENG7105JULY	ADR Yes/No: Y	ADR Date: 16.06.01	ECN #: 16- 591
Product No.: D135-692		Created By: ML	Approved By:	
Product Name: BEARPAW INSTALLATION		Checked By: <i>[Signature]</i>		

Distribution	Reqd	Resp	Initial / Date (YY/MM/DD)
Director of Operations	N	DM	
Production Manager / Coord.	Y	MP / MF	
Purchasing Manager / Purchasing Coord.	N	LL / CL	
Production Engineering Coord.	Y	DD / JLM	
Production Engineering Coord.	N	DL	
Customer Order Processing	N	SL / BG	

Distribution	Reqd	Resp	Initial / Date (YY/MM/DD)
DOA / QA Coord.	Y	PS / ED	
QC Coordinator	Y	PD	
Customer Support	Y	SW / LM	
Customer Technical Support	Y	MB / HS	
Marketing	Y	SL / WR	
Dist. Management Coord.	Y	HM	

Reason for Change:

EXTRA HOLES IN REQUIRED IN BEARPAW AND CLAMPS TO BE RELOCATED TO BE COMPATABLE WITH SKIDTUBES CONFIGURED WITH SNOW SKIS

Documents Affected:

RELEASE D3049 REV. B
RELEASE DSI 9750 REV. A

IF APPLICABLE: NCR: _____ PAR: _____ CAR: _____ CIR: _____ URF: 16-591

PAPERWORK UPDATE ☒

PARTS MUST COMPLY ☐

PREVIOUS PARTS SATISFACTORY ☒

#	Quality Assurance Actions	Reqd	Resp	Notes	Complete
1	Notify Previous Customers	Y	AD	SEE BELOW	☒
2	Notify Eurocopter France	N			
3	Notify Augusta Westland	N			
4	Manufacturing Licensing Agreement Update	N			

#	Engineering Actions	Reqd	Resp	Notes	Complete
5	Required Documents/Drawings/Item ID's Under Review (URF)	N			
6	Update Master Document List (MDL)	Y	ML	RELEASE MDL-D135-692 REV. G	16.06.01 <i>[Signature]</i>
7	Update Document Record (DR)	N			
8	Update Product Compatability Matrix	N			
9	Notify TC / FAA of Change (eg. ICA, 8110-3)	N			
10					

#	Document Control Actions	Reqd	Resp	Notes	Complete
11	Move / Update Electronic Files / Design Journal	Y	KJ		16.07.26 <i>[Signature]</i>
12	Update Product Specification Files (Bluefiles)	Y	KJ		16.07.26 <i>[Signature]</i>
13	Update Approved/Preliminary Dwg PDF Files	Y	KJ		16.07.26 <i>[Signature]</i>
14	Update Product Development Summary (STC applications)	N			
15	Update QSI 021 (TC/FAA STC) and/or STC Approval List	N			
16	Create/Update Parts / STC Database	Y	KJ		16.07.26 <i>[Signature]</i>
17	Update / Verify Airworthiness Release Certificate Database	Y	KJ	#60	16.07.26 <i>[Signature]</i>
18	Create / Update Change Record Form / Item Card Database	Y	KJ		
19	Create / Update Packaging Process Plan (PPP)	Y	KJ		
20	Red Decals required on Packaging Process Plan (PPP)?	N			
21	Update Controlled Supplier Documents (Qpulse) Database	N			
22	Update Grey Project Binder / Electronic Project Folder	Y	KJ		16.07.26 <i>[Signature]</i>
23	Update D-Part / M-Drawing / DSI / DEO Master Binders	Y	KJ	D3049 REV. B	16.07.26 <i>[Signature]</i>
24	Update "Royalty Paid to" attribute (Parts sold under Dart USA STC's)	N			
25					

Description / Action:

ADRIAN D. AND CAITLIN C. TO NOTIFY CUSTOMER(S)
D135-692-011 @ CHG003, DSI 9750-011 @ CHG001, D135-692-041 @ CHG002
D135-692-011 BEARPAW KITS IN STOCK @ CHG002 (QTY 4 AS OF 16.06.01) ARE OKAY TO BE SHIPPED "AS IS" TO CUSTOMERS OTHER THAN
RUAG AND POLISH MEDICAL AIR RESCUE.

ECN Verified & Complete: _____ Date: _____

Kim Johnston

From: David Shepherd
Sent: Sunday, July 24, 2016 8:00 PM
To: William Monterroza; Marc Bellavance
Cc: Support Hawkesbury; Michael Lee; Kim Johnston; Jean-Luc Menard; Denis Maranda; Patrick Smith
Subject: RE: D135-692-011

Will,

Your assessment is correct. I expect FAA acceptance on the latest changes to the EC135 bearpaws sometime this week. In the meantime, I have sent the original data back to Hawkesbury by Fedex for release on an ECN.

Michael Lee should receive this on Monday, July 25th.

FAA acceptance should be a formality at this point ... I am OK with releasing the drawings and manufacturing parts.

Perhaps we could invoke Positive Recall on the Work Orders so that we don't release parts until we get FAA acceptance.

Regards,
David

From: William Monterroza
Sent: July-22-16 11:47 AM
To: Marc Bellavance <mbellavance@dartaero.com>; David Shepherd <dshepherd@dartaero.com>
Cc: Support Hawkesbury <support.on@dartaero.com>; Michael Lee <mlee1@dartaero.com>
Subject: RE: D135-692-011

Marc,

David is following up with the FAA to review and approve this change... we have an ECD of July 29 (next Friday).

Will

From: Marc Bellavance
Sent: Friday, July 22, 2016 1:29 PM
To: David Shepherd <dshepherd@dartaero.com>; William Monterroza <wmonterroza@dartaero.com>
Cc: Support Hawkesbury <support.on@dartaero.com>; Michael Lee <mlee1@dartaero.com>
Subject: FW: D135-692-011
Importance: High

David/Will,

How close are we to release DSI 9750?

Regards,
Marc

From: Caitlin Crooks
Sent: July-22-16 12:57 PM

To: Support Hawkesbury <support.on@dartaero.com>
Subject: RE: D135-692-011

Hi Marc,

PO is from Heliswiss, our distributor, however the end user is SAF Industries in France.

Thanks
Caitlin

From: Support Hawkesbury
Sent: Friday, July 22, 2016 12:47 PM
To: Caitlin Crooks <ccrooks@dartaero.com>
Cc: Support Hawkesbury <support.on@dartaero.com>
Subject: RE: D135-692-011

Hi Caitlin,

Who is your customer?

Regards,
Marc

From: Caitlin Crooks
Sent: July-22-16 12:29 PM
To: Support Hawkesbury <support.on@dartaero.com>
Subject: D135-692-011

Hi Support,

can you advise how long until we are anticipating the review to be released. I have a PO in hand for these bearpaws

Thanks
Caitlin